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means for vibrating a release member with an air cylinder, indicated by reference number 43,
attached to a doctor knife, indicated by reference number 41.

IN THE CLAIMS:

Please enter the following amended claims:

1. (Amended) A set of calender rollers comprising at least three rolling rollers and one feed roller, for rolling a plastic material into a plastic material sheet and for laminating said plastic material sheet onto a base material sheet at a nip portion to be formed into a laminated plastic material sheet, wherein

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said nip portion is formed with a pair of nip rollers including a holding roller for holding said rolled plastic material sheet, and behind said nip portion of a center roller, a release member for releasing said laminated plastic material sheet from said holding roller is arranged in proximity to or in contact with said holding roller, and the feed roller for providing a releasing force to the laminated plastic material sheet is arranged at the position lower than the position of the nip portion.

5. (Twice Amended) A method for producing a laminated sheet by laminating a plastic material sheet on a base material sheet using a set of calender rollers, comprising

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providing said set of calender rollers which comprises at least three rolling rollers and one feed roller, a nip portion is formed with a pair of nip rollers including a holding roller for holding a rolled plastic material sheet, and behind said nip portion of a center roller, a release

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member is arranged in proximity to or in contact with said holding roller, and the feed roller is arranged at the position lower than the position of the nip portion, and

rolling a plastic material into said plastic material sheet, then

laminating said plastic material sheet onto a base material sheet at said nip portion, the resulting laminated sheet remains held on the holding roller due to the tackiness of the plastic material to the position of the release member, and thereafter

releasing the plastic material sheet layer of said laminated sheet from said holding roller by curling it toward the direction of the feed roller with said release member.